

Date: Thursday, 5/4/2006 11:20:09 AM  
 User: Kim Johnston

## Process Sheet

split 83 06/05/15

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : TUBE  
 Job Number : 26996  
 Estimate Number : 12155  
 P.O. Number : N/A Part Number : D34791  
 This Issue : 5/4/2006 S.O. No. : N/A Drawing Number : D3479 REV A  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : A  
 Previous Run : 26476 Material : N/A  
 Due Date : 5/28/2006 Qty: 1/8 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev:A New Issue 06-02-02 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S26GA 304/316 0.018 SHEET



Comment: Qty.: 0.1470 f(s)/Unit Total : 1.1760 f(s)

Pick:

304/316 0.018 SHEET

(M304S26GA)

Batch: M160817

SAD 06:05:09

(8)

2.0 SHEAR SHEAR



Comment: SHEAR

Cut Flat pattern 2.50" X 8.50" as per Dwg D3479

SAD 06:05:09

(8)

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

SAD 06:05:09 (8)

2-Roll part as per Dwg D3479

3-Spot weld as per Dwg D3479 and Dart QSI 018

4-Fabricate Bead using Rotary Machine as per Dwg D3479

MF 07-09-14

(4)

4.0 QC5/9 WELD INSPECTION



Comment: WELD INSPECTION & Work to Current Step

07-09-14

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/02/17

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Thursday, 5/4/2006 11:20:09 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 26996

Part Number: D34791

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

GA MF 07-09-14 (4)

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

4  
D 07/09/17

Job Completion



C 207/09/17



| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

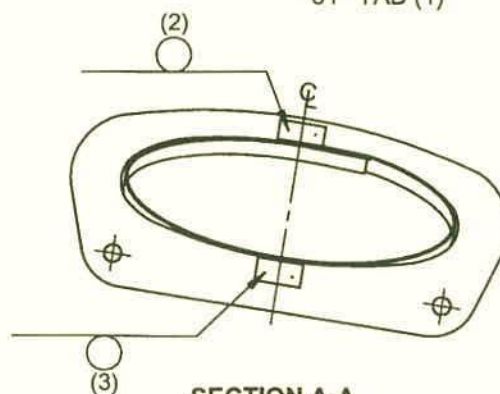
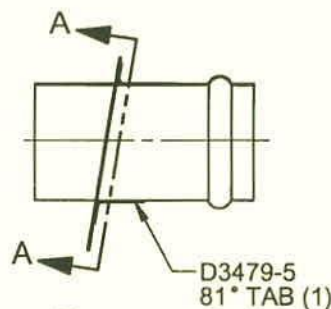
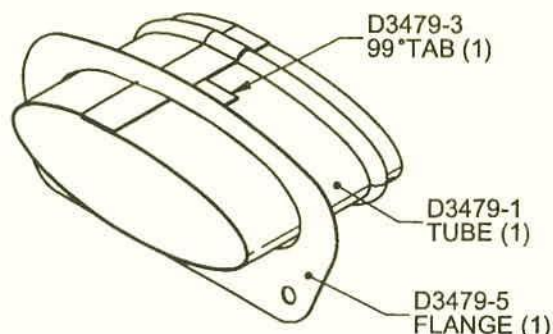
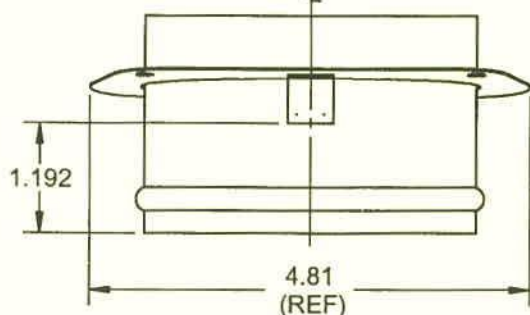
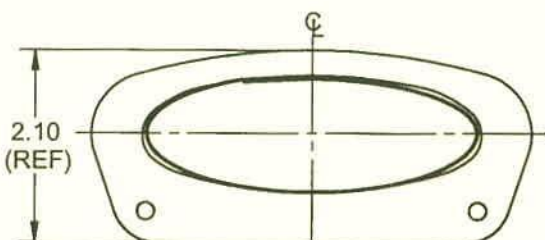
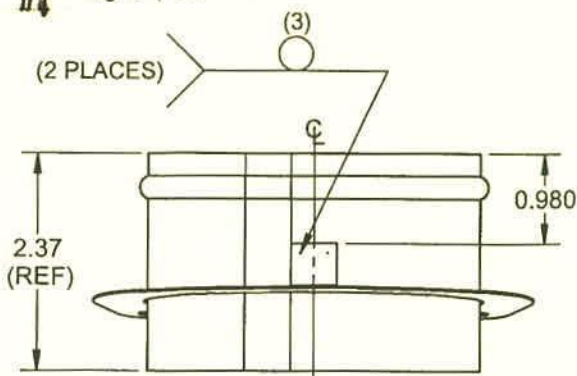
NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|                         |               |  |                        |
|-------------------------|---------------|--|------------------------|
| DESIGN<br>#             | DRAWN BY<br># | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>#            | APPROVED<br># | DRAWING NO.<br><b>D3479</b>                              | REV. A<br>SHEET 1 OF 4 |
| DATE<br><b>06.01.19</b> |               | TITLE<br><b>INLET ADAPTER</b>                            | SCALE<br>1:2           |
| A                       | 06.01.19      | NEW ISSUE  |                        |

# 06.04.03

**SECTION A-A****D3479-041 INLET ADAPTER****NOTES:**

- 1) SPOT WELD PER DART QSI 018
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3479-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

| QTY<br>-041 | P/N       | DESCRIPTION   |
|-------------|-----------|---------------|
| X           | D3479-041 | INLET ADAPTER |
| 1           | D3479-1   | TUBE          |
| 1           | D3479-3   | 99 DEGREE TAB |
| 1           | D3479-5   | 81 DEGREE TAB |
| 1           | D3479-7   | FLANGE        |

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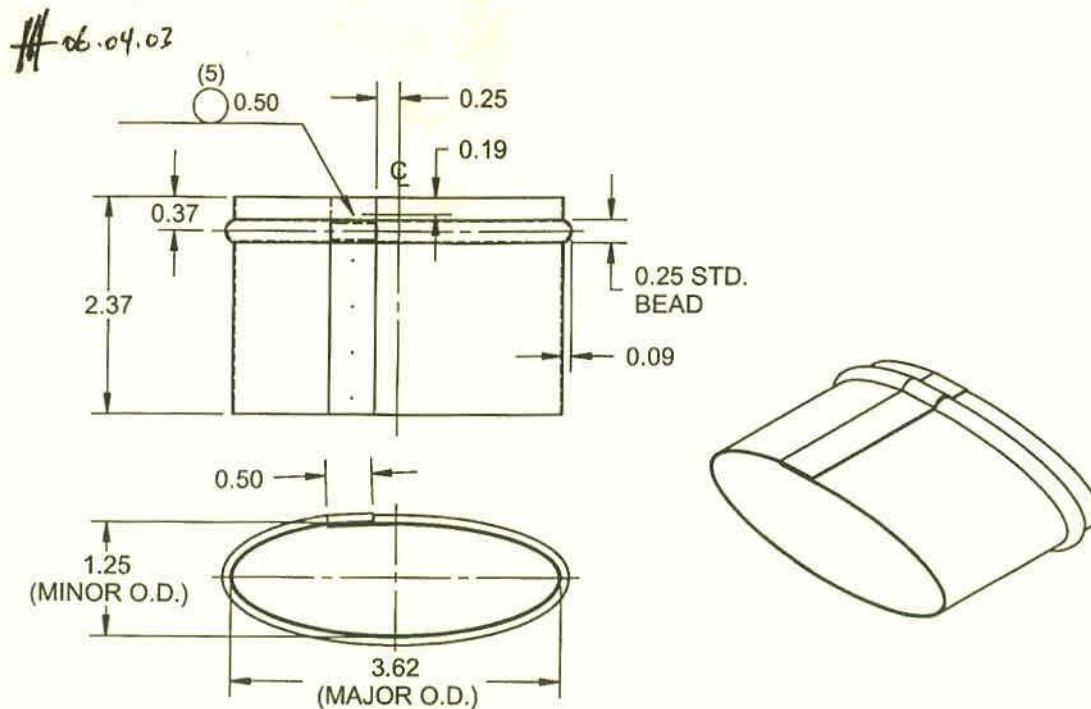
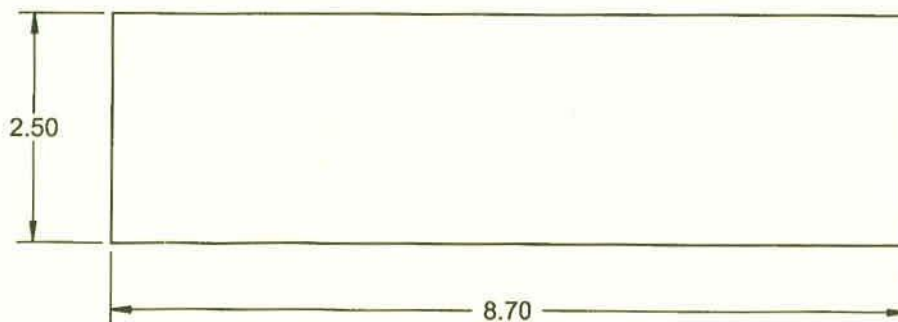
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| CHECKED<br><i>H</i> | APPROVED<br><i>H</i> | DRAWING NO.<br>D3479                              | REV. A<br>SHEET 2 OF 4 |
| DATE<br>06.01.19    |                      | TITLE<br>INLET ADAPTER                            | SCALE<br>1:2           |

**D3479-1 TUBE****D3479-1F FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 018
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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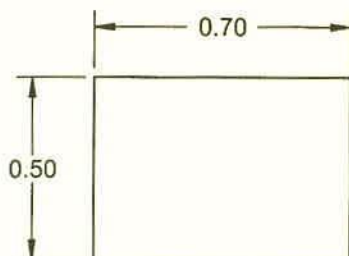
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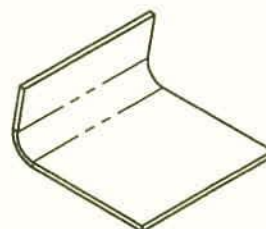
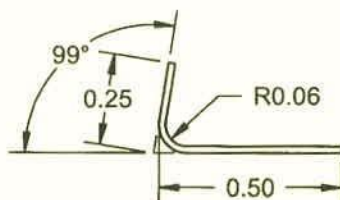
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| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D3479                              | REV. A<br>SHEET 3 OF 4 |
| DATE<br>06.01.19              |                                | TITLE<br>ADAPTER INLET                            | SCALE<br>2:1           |



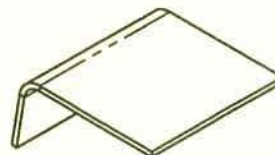
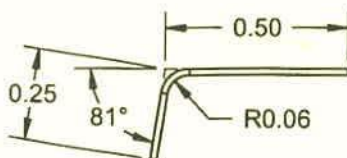
*[Signature]* 06.04.03

### **D3479-3F FLAT PATTERN**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)



### **D3479-3 99 DEGREE TAB** (MAKE FROM D3479-3F FLAT PATTERN)



### **D3479-5 81 DEGREE TAB** (MAKE FROM D3479-3F FLAT PATTERN)

#### **NOTES:**

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

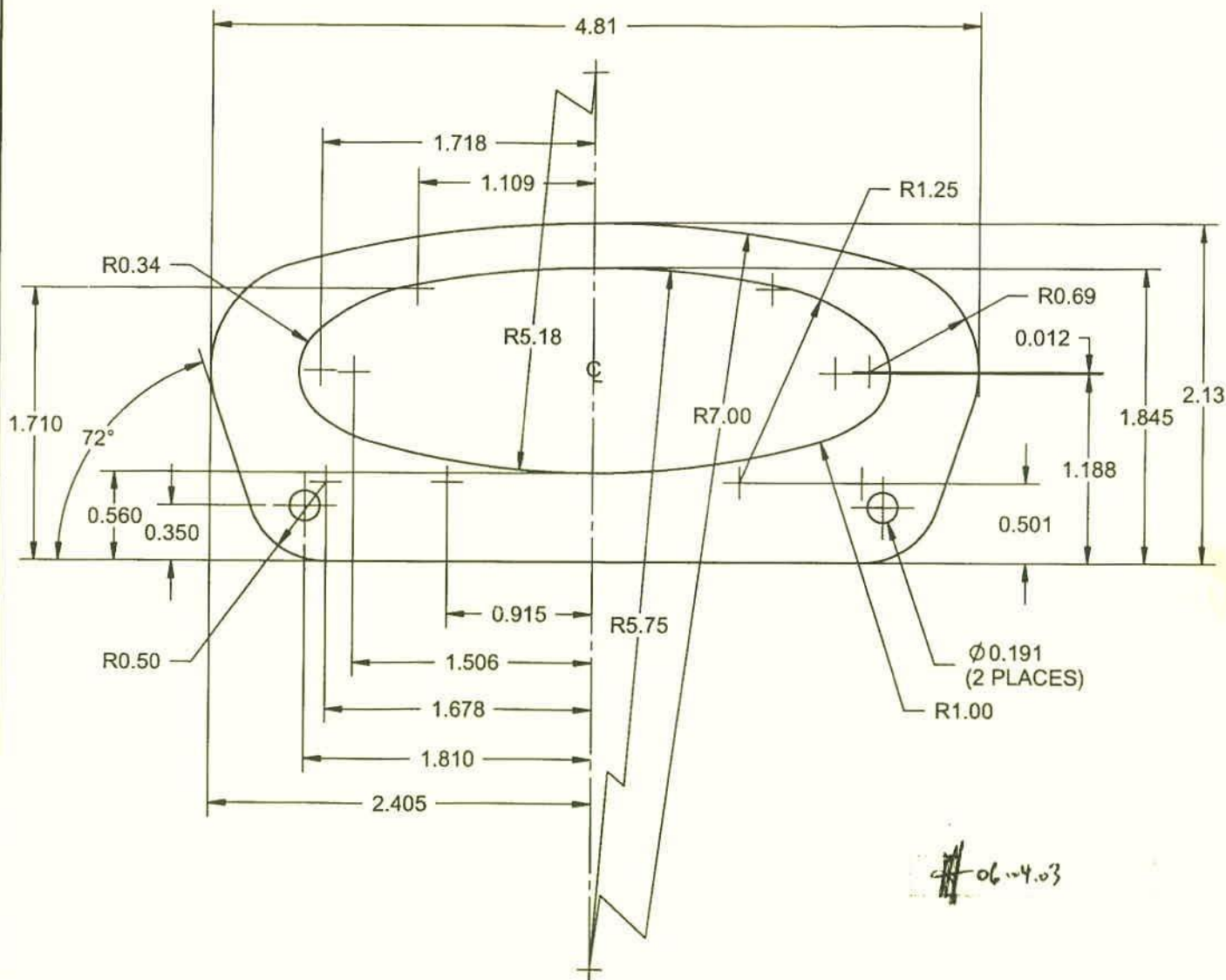
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| DATE<br>06.01.19              |                                | TITLE<br>ADAPTER INLET                            | SCALE<br>1:1           |

**D3479-7 FLANGE PLATE****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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